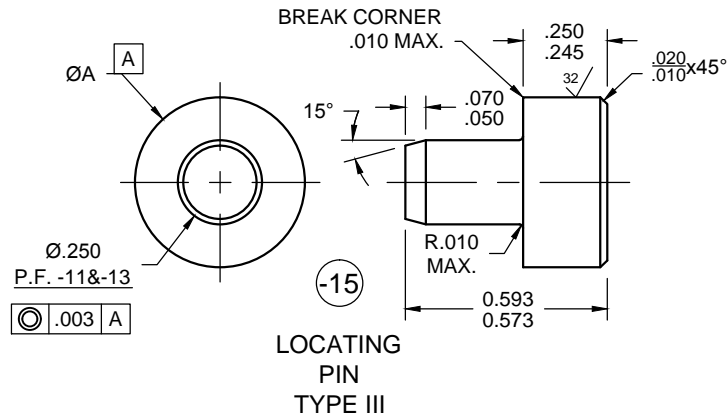



REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED
1	ADDED NOTE TO -1 BODY TO INPECT BEFORE HEAT TREATING, ALSO CHANGED TOL., OF -1 ROLLER FIXTURE'S ØB, ØC, & ØE FROM +.002 -.000.	2/11/08	WP	DW
2	-15 CH'D LOCATING PIN TOLERANCE FROM Ø.2480 Ø.2475 TO Ø.250 P.F. -11 & -13. -11 & -13 CH'D FROM Ø.247 Ø.246 TO REAM Ø.290. REMOVED MS14102 & MS14104 CHAMFERED BEARINGS FROM LIST.	2/19/08	WP	GE
3	ADDED KST2128 & KST2162. -13 REMOVED 25° ANGLE FROM SECONDARY SEAT AND DELETED ØB DIMENSION. ADDED QTY TO -13 & -15 CHART.	4/22/08	WP	DW
4	-5 CH'D ROLLER RADIUS FROM .005 - .010, TO .015 - .020, -9 PIN RADIUS FROM .015 MAX., TO .015 MIN. CH'D -7 SLEEVE TO -7 GUIDE.	7/7/08	WP	DW
4A	CH'D T/N FROM KST2100.	11/19/09	RJC	
5	CORRECTED ERROR -3 WAS .165 NOW .172 FOR ROLLER CLEARANCE. ADDED REVISIONS TO ALL PAGES.	1/18/10	WP	DW
6	-15 DELETED LOCATING PIN TYPE I PER. R.W.	9/10/13	CFS	GE
7	-15 RBST2128 CH'D MATERIAL SIZE FROM Ø5/8 X 5/8 TO Ø3/4 X 5/8 & RBST2162 FROM Ø3/8 X 5/8 TO Ø1/2 X 5/8.	11/5/13	JAG	GE

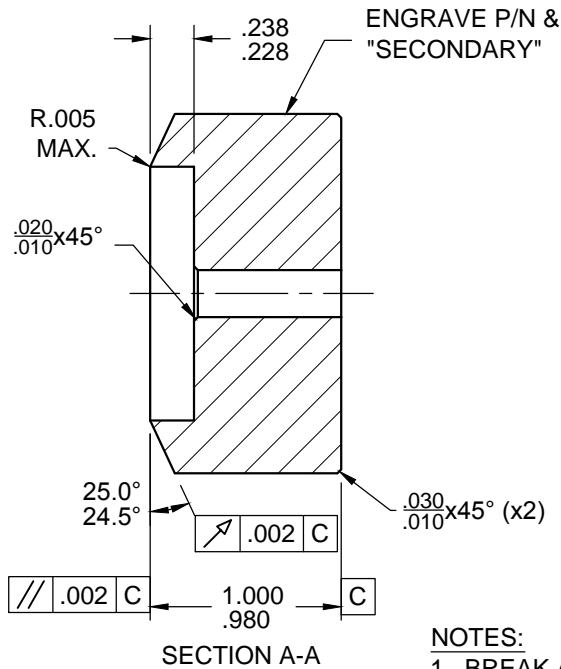
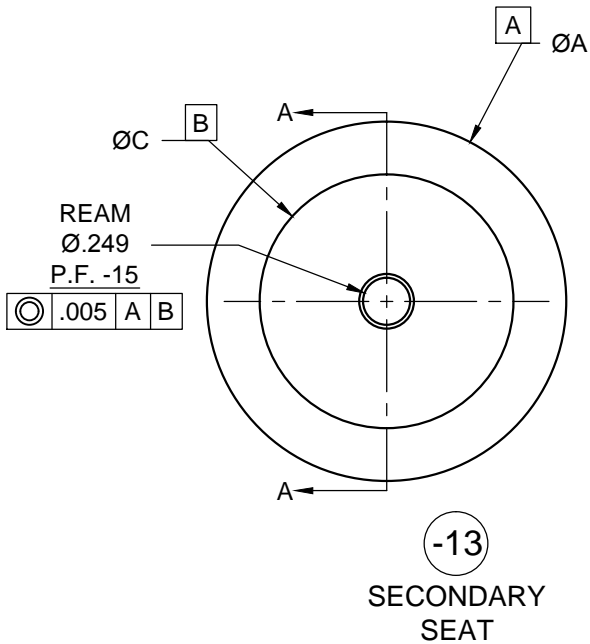


NOTES:
1. BREAK ALL SHARP CORNERS (.015/.03).

 RED BARN MACHINE	
TITLE RBST2100 SERIES TRI-ROLLER SWAGING TOOL; LOCATING PIN	
DWG NO. TOOL# (see chart)-15	REV 7
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
TOLERANCES ON: DECIMALS .XXX ± .005 FRACTIONS ± 1/32 .XX ± .01 ANGLES ± 5° X ± .1	
DRAWN BY: PERRITT APPROVED <i>D Weil</i>	
HEAT TREAT FINISH BLACK OXIDE USED ON BEARING	
SEE Pg. 1	
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE NTS	DATE 1-23-08 SHEET 9 of 9


TOOL #	ØA +.000 -.002	PIN TYPE	QTY.	MATERIAL
RBST2120	.310	III	2	1018 RND. BAR Ø3/8 x 5/8
RBST2128	.622	III	1	1018 RND. BAR Ø3/4 x 5/8
RBST2162	.372	III	1	1018 RND. BAR Ø1/2 x 5/8

REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED
1	ADDED NOTE TO -1 BODY TO INPECT BEFORE HEAT TREATING, ALSO CHANGED TOL., OF -1 ROLLER FIXTURE'S ØB, ØC, & ØE FROM +.002 -.000.	2/11/08	WP	DW
2	-15 CH'D LOCATING PIN TOLERANCE FROM Ø.2480 Ø.2475 TO Ø.250 P.F. -11 & -13. -11 & -13 CH'D FROM Ø.247 Ø.246 TO REAM Ø.290. REMOVED MS14102 & MS14104 CHAMFERED BEARINGS FROM LIST.	2/19/08	WP	GE
3	ADDED KST2128 & KST2162. -13 REMOVED 25° ANGLE FROM SECONDARY SEAT AND DELETED ØB DIMENSION. ADDED QTY TO -13 & -15 CHART.	4/22/08	WP	DW
4	-5 CH'D ROLLER RADIUS FROM .005 -.010, TO .015 -.020, -9 PIN RADIUS FROM .015 MAX., TO .015 MIN. CH'D -7 SLEEVE TO -7 GUIDE.	7/7/08	WP	DW
4A	CH'D T/N FROM KST2100.	11/19/09	RJC	
5	CORRECTED ERROR -3 WAS .165 NOW .172 FOR ROLLER CLEARANCE. ADDED REVISIONS TO ALL PAGES.	1/18/10	WP	DW

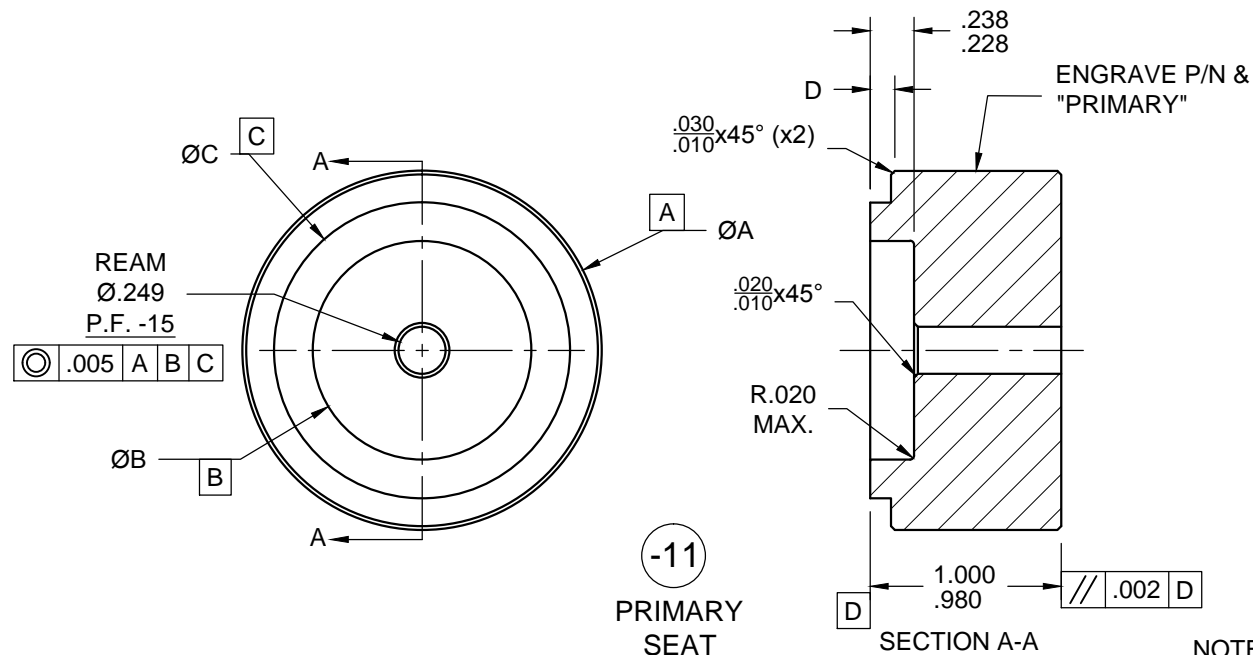


NOTES:
1. BREAK ALL SHARP CORNERS (.015/.03).

TOOL #	QTY.	ØA + .000 - .030	ØC + .000 - .005	MATERIAL
RBST2120	1	1.360	.968	4140 Q&T RND. BAR Ø1-3/8 x 1-1/8
RBST2128	0	0	0	NONE
RBST2162	0	0	0	NONE

 RED BARN MACHINE	
TITLE RBST2100 SERIES TRI-ROLLER SWAGING TOOL; SECONDARY SEAT	
DWG NO. TOOL# (see chart)-13	REV 7
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON: DECIMALS .XXX ± .005 FRACTIONS ± 1/32 .XX ± .01 ANGLES ± 5° X ± .1	
DRAWN BY: PERRITT APPROVED <i>D Weil</i>	
HEAT TREAT BLACK OXIDE FINISH USED ON BEARING	
SEE Pg. 1	
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE NTS	DATE 1-23-08
SHEET 8 of 9	

REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED
1	ADDED NOTE TO -1 BODY TO INPECT BEFORE HEAT TREATING, ALSO CHANGED TOL., OF -1 ROLLER FIXTURE'S ØB, ØC, & ØE FROM +.002 -.000.	2/11/08	WP	DW
2	-15 CH'D LOCATING PIN TOLERANCE FROM Ø.2480 Ø.2475 TO Ø.250 P.F. -11 & -13. -11 & -13 CH'D FROM Ø.247 Ø.246 TO REAM Ø.290. REMOVED MS14102 & MS14104 CHAMFERED BEARINGS FROM LIST.	2/19/08	WP	GE
3	ADDED KST2128 & KST2162. -13 REMOVED 25° ANGLE FROM SECONDARY SEAT AND DELETED ØB DIMENSION. ADDED QTY TO -13 & -15 CHART.	4/22/08	WP	DW
4	-5 CH'D ROLLER RADIUS FROM .005 -.010, TO .015 -.020, -9 PIN RADIUS FROM .015 MAX., TO .015 MIN. CH'D -7 SLEEVE TO -7 GUIDE.	7/7/08	WP	DW
4A	CH'D T/N FROM KST2100.	11/19/09	RJC	
5	CORRECTED ERROR -3 WAS .165 NOW .172 FOR ROLLER CLEARANCE. ADDED REVISIONS TO ALL PAGES.	1/18/10	WP	DW



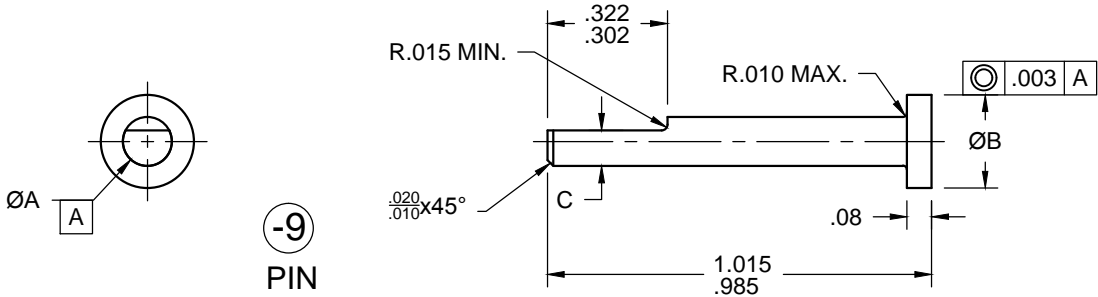
NOTES:

- BREAK ALL SHARP CORNERS (.015/.03).

TOOL #	ØA +.000 -.030	ØB +.000 -.005	ØC +.002 -.002	D +.002 -.002	MATERIAL
RBST2120	1.360	.875	0	0	4140 Q&T RND. BAR Ø1-3/8 x 1-1/8
RBST2128	1.870	1.139	0	0	4140 Q&T RND. BAR Ø1-7/8 x 1-1/8
RBST2162	1.485	.881	1.183	.053	4140 Q&T RND. BAR Ø1-1/2 x 1-1/8


RED BARN MACHINE	
TITLE RBST2100 SERIES TRI-ROLLER SWAGING TOOL; PRIMARY SEAT	
DWG NO. TOOL# (see chart)-11	REV 7
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON: DECIMALS .XXX ± .005 .XX ± .01 .X ± .1	DRAWN BY: PERRITT APPROVED: <i>D Weil</i> HEAT TREAT: BLACK OXIDE FINISH SPEC: USED ON BEARING SEE Pg. 1
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES 015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE NTS	DATE 1-23-08 SHEET 7 of 9

REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED
1	ADDED NOTE TO -1 BODY TO INPECT BEFORE HEAT TREATING, ALSO CHANGED TOL., OF -1 ROLLER FIXTURE'S ØB, ØC, & ØE FROM +.002 -.000.	2/11/08	WP	DW
2	-15 CH'D LOCATING PIN TOLERANCE FROM Ø.2480 Ø.2475 TO Ø.250 P.F. -11 & -13. -11 & -13 CH'D FROM Ø.247 Ø.246 TO REAM Ø.290. REMOVED MS14102 & MS14104 CHAMFERED BEARINGS FROM LIST.	2/19/08	WP	GE
3	ADDED KST2128 & KST2162. -13 REMOVED 25° ANGLE FROM SECONDARY SEAT AND DELETED ØB DIMENSION. ADDED QTY TO -13 & -15 CHART.	4/22/08	WP	DW
4	-5 CH'D ROLLER RADIUS FROM .005 -.010, TO .015 -.020, -9 PIN RADIUS FROM .015 MAX., TO .015 MIN. CH'D -7 SLEEVE TO -7 GUIDE.	7/7/08	WP	DW
4A	CH'D T/N FROM KST2100.	11/19/09	RJC	
5	CORRECTED ERROR -3 WAS .165 NOW .172 FOR ROLLER CLEARANCE. ADDED REVISIONS TO ALL PAGES.	1/18/10	WP	DW

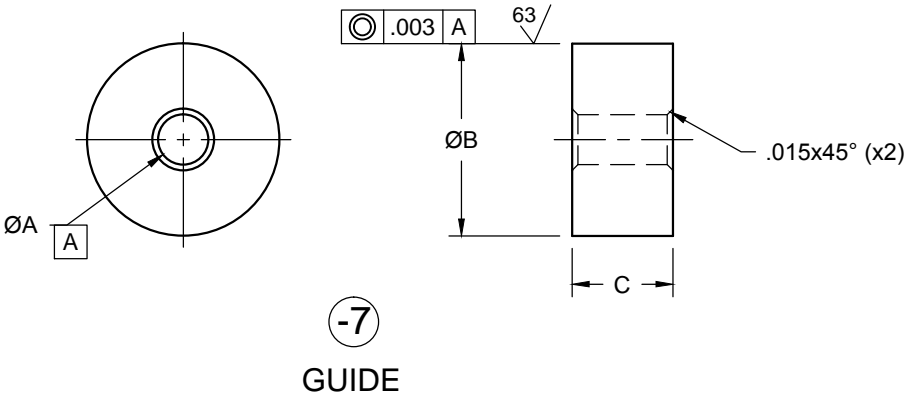


NOTES:
1. BREAK ALL SHARP CORNERS (.015/.03).

TOOL #	ØA +.000 -.001	ØB +.005 -.002	C +.000 -.020	MATERIAL
RBST2120	.129	.188	.104	MCMaster-CARR PN: 98378A909
RBST2128	.129	.188	.104	MCMaster-CARR PN: 98378A909
RBST2162	.129	.188	.104	MCMaster-CARR PN: 98378A909

 RED BARN MACHINE	
TITLE RBST2100 SERIES TRI-ROLLER SWAGING TOOL; PIN	
DWG NO. TOOL# (see chart)-9	REV 7
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON: DECIMALS .XXX ± .005 .XX ± .01 X ± .1 FRACTIONS ± 1/32 ANGLES ± 5°	DRAWN BY: PERRITT APPROVED <i>D Weil</i> HEAT TREAT FINISH BLACK OXIDE USED ON BEARING SEE Pg. 1
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE NTS	DATE 1-23-08
SHEET 6 of 9	


REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED
1	ADDED NOTE TO -1 BODY TO INPECT BEFORE HEAT TREATING, ALSO CHANGED TOL., OF -1 ROLLER FIXTURE'S ØB, ØC, & ØE FROM +.002 -.000.	2/11/08	WP	DW
2	-15 CH'D LOCATING PIN TOLERANCE FROM Ø.2480 Ø.2475 TO Ø.250 P.F. -11 & -13. -11 & -13 CH'D FROM Ø.247 Ø.246 TO REAM Ø.290. REMOVED MS14102 & MS14104 CHAMFERED BEARINGS FROM LIST.	2/19/08	WP	GE
3	ADDED KST2128 & KST2162. -13 REMOVED 25° ANGLE FROM SECONDARY SEAT AND DELETED ØB DIMENSION. ADDED QTY TO -13 & -15 CHART.	4/22/08	WP	DW
4	-5 CH'D ROLLER RADIUS FROM .005 - .010, TO .015 - .020, -9 PIN RADIUS FROM .015 MAX., TO .015 MIN. CH'D -7 SLEEVE TO -7 GUIDE.	7/7/08	WP	DW
4A	CH'D T/N FROM KST2100.	11/19/09	RJC	
5	CORRECTED ERROR -3 WAS .165 NOW .172 FOR ROLLER CLEARANCE. ADDED REVISIONS TO ALL PAGES.	1/18/10	WP	DW




NOTES

1. BREAK ALL SHARP CORNERS (.015/.03).

TOOL #	ØA +.001 -.001	ØB +.000 -.002	C +.000 -.010	MATERIAL
RBST2120	.131	.310	.390	BRONZE RND. BAR Ø5/16 x 1/2
RBST2128	.131	.622	.312	BRONZE RND. BAR Ø5/8 x 1/2
RBST2162	.131	.372	.312	BRONZE RND. BAR Ø3/8 x 1/2

 RED BARN MACHINE	
TITLE RBST2100 SERIES TRI-ROLLER SWAGING TOOL; GUIDE	
DWG NO. TOOL# (see chart)-7	REV 7
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
TOLERANCES ON: DECIMALS .XXX ± .005 FRACTIONS ± 1/32 .XX ± .01 ANGLES ± 5° X ± .1	
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE NTS	DATE 1-23-08
SHEET 5 of 9	

DRAWN BY: PERRITT

APPROVED 

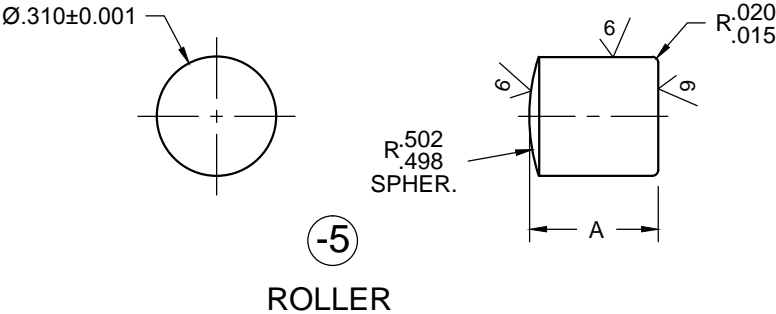
HEAT TREAT

FINISH SPEC

USED ON BEARING


SEE Pg. 1

REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED
1	ADDED NOTE TO -1 BODY TO INPECT BEFORE HEAT TREATING, ALSO CHANGED TOL., OF -1 ROLLER FIXTURE'S ØB, ØC, & ØE FROM +.002 -.000.	2/11/08	WP	DW
2	-15 CH'D LOCATING PIN TOLERANCE FROM Ø.2480 Ø.2475 TO Ø.250 P.F. -11 & -13. -11 & -13 CH'D FROM Ø.247 Ø.246 TO REAM Ø.290. REMOVED MS14102 & MS14104 CHAMFERED BEARINGS FROM LIST.	2/19/08	WP	GE
3	ADDED KST2128 & KST2162. -13 REMOVED 25° ANGLE FROM SECONDARY SEAT AND DELETED ØB DIMENSION. ADDED QTY TO -13 & -15 CHART.	4/22/08	WP	DW
4	-5 CH'D ROLLER RADIUS FROM .005 - .010, TO .015 - .020, -9 PIN RADIUS FROM .015 MAX., TO .015 MIN. CH'D -7 SLEEVE TO -7 GUIDE.	7/7/08	WP	DW
4A	CH'D T/N FROM KST2100.	11/19/09	RJC	
5	CORRECTED ERROR -3 WAS .165 NOW .172 FOR ROLLER CLEARANCE. ADDED REVISIONS TO ALL PAGES.	1/18/10	WP	DW

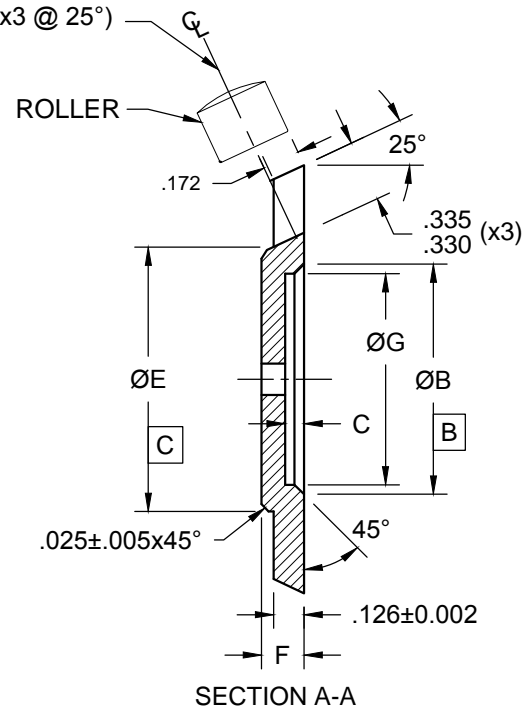
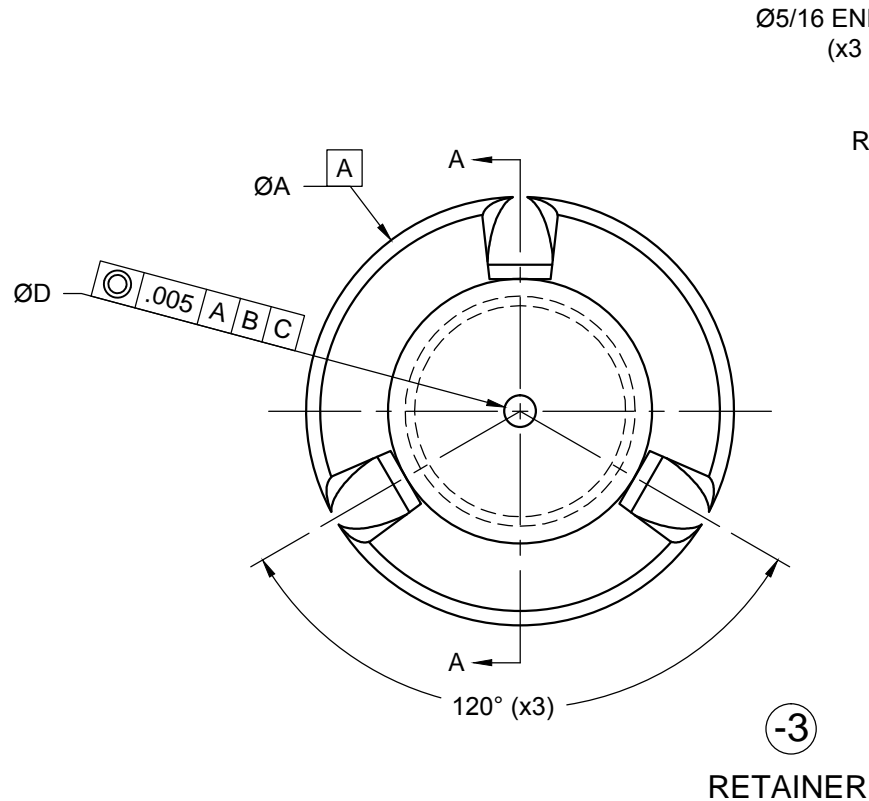


ROLLER

TOOL #	A +.001 -.001	MATERIAL		
RBST2120	.335	.310 MINUS	GAUGE PIN	MSC#89031009
RBST2128	.335	.310 MINUS	GAUGE PIN	MSC#89031009
RBST2162	.335	.310 MINUS	GAUGE PIN	MSC#89031009

 RED BARN MACHINE	
TITLE RBST2100 SERIES TRI-ROLLER SWAGING TOOL; ROLLER (QTY. 3)	
DWG NO. TOOL# (see chart)-5	REV 7
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON: DECIMALS .XXX ± .005 FRACTIONS ± 1/32 .XX ± .01 ANGLES ± 5° X ± .1	DRAWN BY: PERRITT APPROVED <i>D Weil</i> HEAT TREAT RC 55-60 FINISH SPEC USED ON BEARING SEE Pg. 1
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE NTS	DATE 1-23-08
SHEET 4 of 9	

REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED
1	ADDED NOTE TO -1 BODY TO INPECT BEFORE HEAT TREATING, ALSO CHANGED TOL., OF -1 ROLLER FIXTURE'S ØB, ØC, & ØE FROM +.002 -.000.	2/11/08	WP	DW
2	-15 CH'D LOCATING PIN TOLERANCE FROM Ø.2480 Ø.2475 TO Ø.250 P.F. -11 & -13. -11 & -13 CH'D FROM Ø.247 Ø.246 TO REAM Ø.290. REMOVED MS14102 & MS14104 CHAMFERED BEARINGS FROM LIST.	2/19/08	WP	GE
3	ADDED KST2128 & KST2162. -13 REMOVED 25° ANGLE FROM SECONDARY SEAT AND DELETED ØB DIMENSION. ADDED QTY TO -13 & -15 CHART.	4/22/08	WP	DW
4	-5 CH'D ROLLER RADIUS FROM .005 - .010, TO .015 - .020, -9 PIN RADIUS FROM .015 MAX., TO .015 MIN. CH'D -7 SLEEVE TO -7 GUIDE.	7/7/08	WP	DW
4A	CH'D T/N FROM KST2100.	11/19/09	RJC	
5	CORRECTED ERROR -3 WAS .165 NOW .172 FOR ROLLER CLEARANCE. ADDED REVISIONS TO ALL PAGES.	1/18/10	WP	DW



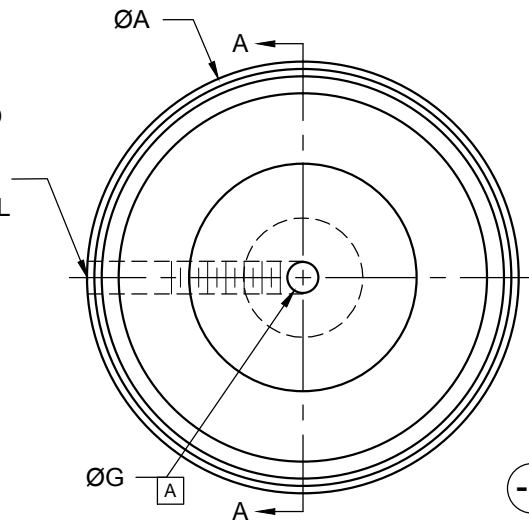
TOOL #	ØA +.002 -.002	ØB +.010 -.005	C +.020 -.000	ØD +.004 -.001	ØE +.000 -.015	F +.010 -.010	ØG +.010 -.005	P.D. REF.	MATERIAL
RBST2120	1.540	.700	.150	.136	.644	.210	.530	.968	BRONZE RND. BAR Ø1-5/8 x 3/8
RBST2128	1.857	1.077	.070	.136	0	0	.937	1.283	BRONZE RND. BAR Ø1-7/8 x 1/4
RBST2162	1.610	.775	.072	.136	0	0	.631	1.025	BRONZE RND. BAR Ø1-5/8 x 1/4

- NOTES
1. BREAK ALL SHARP CORNERS
(.015/.03).

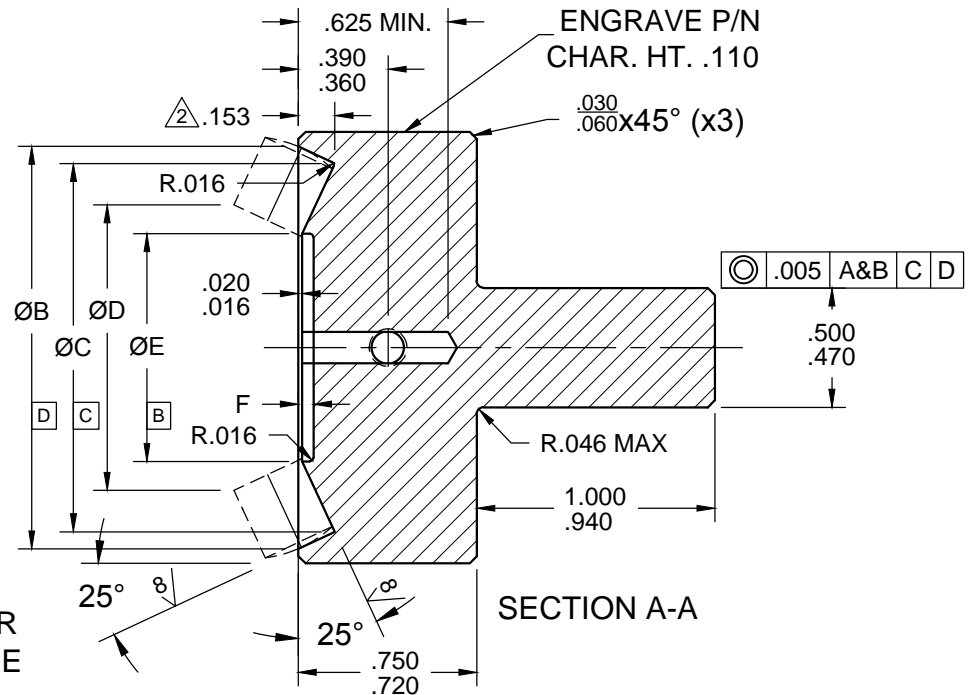
RED BARN MACHINE	
TITLE RBST2100 SERIES TRI-ROLLER SWAGING TOOL; RETAINER	
DWG NO. TOOL# (see chart)-3	REV 7
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
TOLERANCES ON: DECIMALS .XXX ± .005 FRACTIONS ± 1/32 XX ± .01 X ± .1 ANGLES ± 5°	
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE NTS	DATE 1-23-08
SHEET 3 of 9	
DRAWN BY: PERRITT APPROVED: <i>D Weil</i> HEAT TREAT FINISH SPEC USED ON BEARING SEE Pg. 1	

REVISIONS					
REV	DESCRIPTION	DATE	INITIAL	APPROVED	
1	ADDED NOTE TO -1 BODY TO INSPECT BEFORE HEAT TREATING, ALSO CHANGED TOL., OF -1 ROLLER FIXTURE'S ØB, ØC, & ØE FROM +.002 -.000.	2/11/08	WP	DW	
2	-15 CH'D LOCATING PIN TOLERANCE FROM Ø.2480 Ø.2475 TO Ø.250 P.F. -11 & -13. -11 & -13 CH'D FROM Ø.247 Ø.246 TO REAM Ø.290. REMOVED MS14102 & MS14104 CHAMFERED BEARINGS FROM LIST.	2/19/08	WP	GE	
3	ADDED KST2128 & KST2162. -13 REMOVED 25° ANGLE FROM SECONDARY SEAT AND DELETED ØB DIMENSION. ADDED QTY TO -13 & -15 CHART.	4/22/08	WP	DW	
4	-5 CH'D ROLLER RADIUS FROM .005 -.010, TO .015 -.020, -9 PIN RADIUS FROM .015 MAX., TO .015 MIN. CH'D -7 SLEEVE TO -7 GUIDE.	7/7/08	WP	DW	
4A	CH'D T/N FROM KST2100.	11/19/09	RJC		
5	CORRECTED ERROR -3 WAS .165 NOW .172 FOR ROLLER CLEARANCE. ADDED REVISIONS TO ALL PAGES.	1/18/10	WP	DW	
6	-1 RBST2128 CH'D ØB WAS 1.802 IS 1.776, CH'D ØE WAS 1.042 IS 1.028.	9/10/13	CFS	GE	

#8-32 UNC THRD
LENGTH 3/8 MIN.
C-BORE Ø.187
DEPTH OPTIONAL



ROLLER
FIXTURE



NOTES

- BREAK ALL SHARP CORNERS (.015/.03).
DIMENSION TO BOTTOM OF R.016=.153;
DIMENSION TO SHARP CORNER=.158.
- 1 BEARING RACE SURFACES MUST HAVE
SMOOTH APPEARANCE, FREE FROM
MACHINING MARKS AND GROOVES.
- DO FIRST ARTICLE INSPECTION
BEFORE HEAT TREATING.

TOOL #	ØA +.000 -.030	ØB +.008 -.000	ØC +.008 -.000	ØD P.D. REF.	ØE +.008 -.000	F +.030 -.000	ØG +.000 +.001	MATERIAL
RBST2120	1.735	1.463	1.314	.968	.698	.130	.131	0-1 DRILL ROD Ø1-3/4 x 1-7/8
RBST2128	2.000	1.776	1.629	1.283	1.028	0	.131	0-1 DRILL ROD Ø2 x 1-7/8
RBST2162	1.875	1.521	1.375	1.031	.767	0	.131	0-1 DRILL ROD Ø2 x 1-7/8

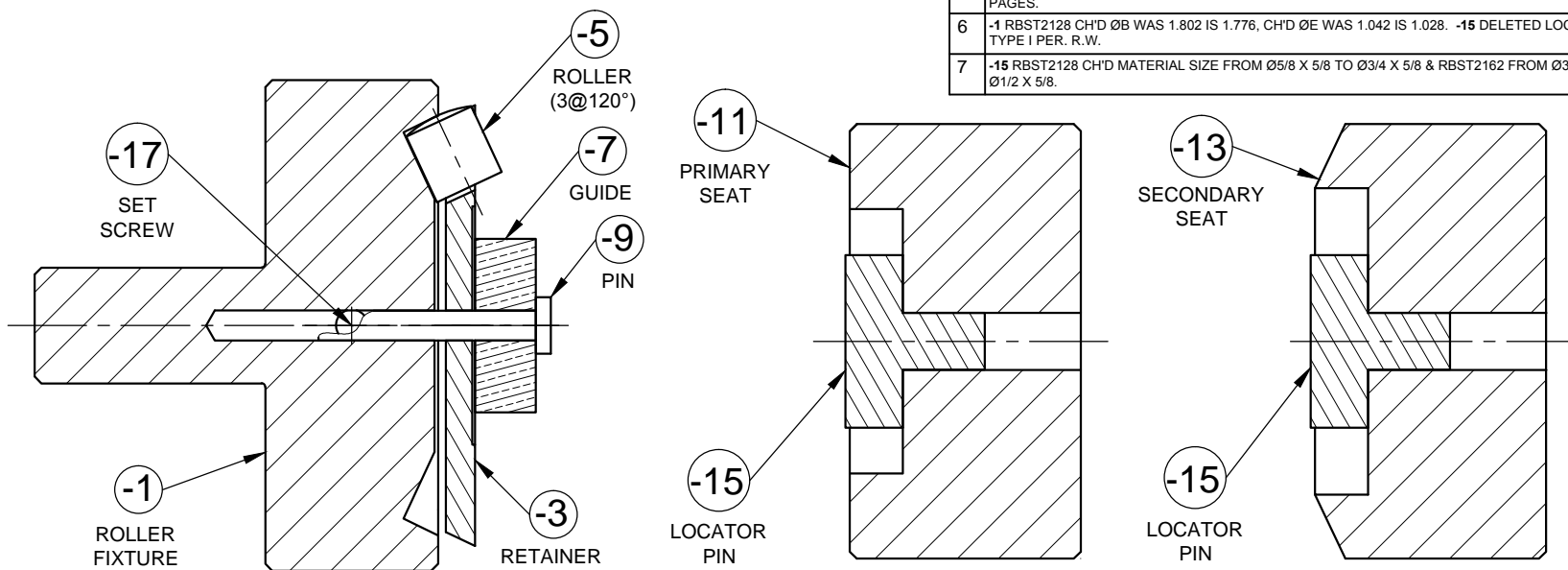


RED BARN MACHINE

TITLE RBST2100 SERIES TRI-ROLLER SWAGING TOOL; ROLLER FIXTURE		
DWG NO. TOOL# (see chart)-1		REV 7
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON: DECIMALS .XXX ± .005 .XX ± .01 .X ± .1 FRACTIONS ± 1/32 ANGLES ± 5°		DRAWN BY: PERRITT APPROVED: <i>D Weil</i> HEAT TREAT RC 55-60 FINISH BLACK OXIDE SPEC
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING		USED ON BEARING SEE Pg. 1
SCALE NTS	DATE 1-23-08	SHEET 2 of 9

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REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED
1	ADDED NOTE TO -1 BODY TO INSPECT BEFORE HEAT TREATING, ALSO CHANGED TOL., OF -1 ROLLER FIXTURE'S ØB, ØC, & ØE FROM +.002 -.000.	2/11/08	WP	DW
2	-15 CH'D LOCATING PIN TOLERANCE FROM Ø.2480 Ø.2475 TO Ø.250 P.F. -11 & -13. -11 & -13 CH'D FROM Ø.247 Ø.246 TO REAM Ø.290. REMOVED MS14102 & MS14104 CHAMFERED BEARINGS FROM LIST.	2/19/08	WP	GE
3	ADDED KST2128 & KST2162. -13 REMOVED 25° ANGLE FROM SECONDARY SEAT AND DELETED ØB DIMENSION. ADDED QTY TO -13 & -15 CHART.	4/22/08	WP	DW
4	-5 CH'D ROLLER RADIUS FROM .005 - .010, TO .015 - .020, -9 PIN RADIUS FROM .015 MAX., TO .015 MIN. CH'D -7 SLEEVE TO -7 GUIDE.	7/7/08	WP	DW
4A	CH'D T/N FROM KST2100.	11/19/09	RJC	
5	CORRECTED ERROR -3 WAS .165 NOW .172 FOR ROLLER CLEARANCE. ADDED REVISIONS TO ALL PAGES.	1/18/10	WP	DW
6	-1 RBST2128 CH'D ØB WAS 1.802 IS 1.776, CH'D ØE WAS 1.042 IS 1.028. -15 DELETED LOCATING PIN TYPE I PER. R.W.	9/10/13	CFS	GE
7	-15 RBST2128 CH'D MATERIAL SIZE FROM Ø5/8 X 5/8 TO Ø3/4 X 5/8 & RBST2162 FROM Ø3/8 X 5/8 TO Ø1/2 X 5/8.	11/5/13	JAG	GE



BEARINGS & TOOLS COVERED	
BEARING #	TOOL #
406-310-403-101	RBST2120
412-010-427-101	RBST2128
406-312-100-101	RBST2162


NOTES

- 5 ROLLERS MUST TURN FREELY IN -3 RETAINER POCKETS.
- 5 ROLLERS & -3 RETAINER MUST TURN FREELY WHEN TOOL IS COMPLETELY ASSEMBLED.
- FLAT END OF ROLLERS MUST FACE TOWARDS THE CENTER OF THE TOOL WHEN ASSEMBLED.

ASSY QTY	B/O	PART #	UNIT QTY	DESCRIPTION	B/O INFORMATION OR SPECIFICATIONS	Pg.
		-1	1	ROLLER FIXTURE	SEE CHART	2
		-3	1	RETAINER	SEE CHART	3
		-5	3	ROLLER	SEE CHART	4
		-7	1	GUIDE	SEE CHART	5
		-9	1	PIN	SEE CHART	6
		-11	1	PRIMARY SEAT	SEE CHART	7
		-13	0 or 1	SECONDARY SEAT	SEE CHART	8
		-15	1 or 2	LOCATING PIN	SEE CHART	9
	B/O	-17	1	SOCKET HEAD SET SCREW	#8-32 x 1/4	N/S

TITLE		RBST2100 SERIES TRI-ROLLER SWAGING TOOL; ASSEMBLY	
DWG NO.	TOOL# (see chart above)		REV 7
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		DRAWN BY: PERRITT	
TOLERANCES ON:		APPROVED <i>D Weil</i>	
DECIMALS .XXX ± .005		HEAT TREAT LISTED PER ITEM	
FRACTIONS ± 1/32		FINISH LISTED PER ITEM	
ANGLES ± 5°		USED ON BEARING	
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R		SEE ABOVE	
2. DIMENSIONAL LIMITS APPLY AFTER PLATING			
SCALE	NTS	DATE	1-4-08
		SHEET	1 of 9

[illegible]

 <h1>RED BARN MACHINE</h1>	
TITLE --	
DWG NO. --	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
TOLERANCES ON:	
DECIMALS	
.XXX ± .005	
.XX ± .01	
.X ± .1	
FRACTIONS ± 1/32	
ANGLES ± 5°	
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
DRAWN BY: PERRITT	
APPROVED	
HEAT TREAT	
FINISH	
SPEC	
USED ON MODEL	
SCALE NTS DATE 8-15-07 SHEET 1 of 1	

NOT APPROVED FOR PRODUCTION

REVISIONS			
REV	DESCRIPTION	DATE	APPROVED

PART #	QTY	DESCRIPTION
-1	1	--

USED ON MODEL ? 	DRAWN BY: PERRITT	<div><div>RB</div><div>RED BARN MACHINE</div></div>	
	CHECKED		
	HEAT TREAT FINISH SPEC	TITLE	
	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON: DECIMALS .XXX ± .005 .XX ± .01 .X ± .1	PART #	
	UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	SCALE NTS	DATE 1-28-06 SHEET 1 of 1

TEST SUBJECT
NOT APPROVED FOR PRODUCTION

QTY	DESCRIPTION
1	0-1 DRILL ROD Ø2-1/8 x 1-7/8
1	BRASS RND Ø2 x 5/16
3	0-1 DRILL ROD Ø3/8 x 1/2

NOTES

1. ENGRAVE P/N; CHARACTER H
2. ENGRAVE 'PRIMARY'
3. ENGRAVE 'SECONDARY'

DRAWN BY: PERRITT

APPROVED

HEAT

RB

RED BARN MACHINE CO.

TEST SUBJECT NOT APPROVED FOR PRODUCTION

QTY	DESCRIPTION
1	0-1 DRILL ROD Ø2-1/8 x 1-7/8
1	BRASS RND Ø2 x 5/16
3	0-1 DRILL ROD Ø3/8 x 1/2

NOTES

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DRAWN BY: PERRITT

APPROVED

HEAT

RB RED BARN MACHINE CO.

TEST SUBJECT NOT APPROVED FOR PRODUCTION

QTY	DESCRIPTION
1	0-1 DRILL ROD Ø2-1/8 x 1-7/8
1	BRASS RND Ø2 x 5/16
3	0-1 DRILL ROD Ø3/8 x 1/2

NOTES

1. ENGRAVE P/N; CHARACTER H
2. ENGRAVE 'PRIMARY'
3. ENGRAVE 'SECONDARY'

DRAWN BY: PERRITT

APPROVED

HEAT

RB

RED BARN MAC

- TEST SUBJECT NOT APPROVED FOR PRODUCTION

QTY	DESCRIPTION
1	0-1 DRILL ROD Ø2-1/8 x 1-7/8
1	BRASS RND Ø2 x 5/16
3	0-1 DRILL ROD Ø3/8 x 1/2

NOTES

 1. ENGRAVE P/N; CHARACTER H
 2. ENGRAVE 'PRIMARY'
 3. ENGRAVE 'SECONDARY'

DRAWN BY: PERRITT

APPROVED

HEAT

RB

RED BARN MACHINE CO.

TEST SUBJECT NOT APPROVED FOR PRODUCTION

QTY	DESCRIPTION
1	0-1 DRILL ROD Ø2-1/8 x 1-7/8
1	BRASS RND Ø2 x 5/16
3	0-1 DRILL ROD Ø3/8 x 1/2

NOTES

1. ENGRAVE P/N; CHARACTER H
2. ENGRAVE 'PRIMARY'
3. ENGRAVE 'SECONDARY'

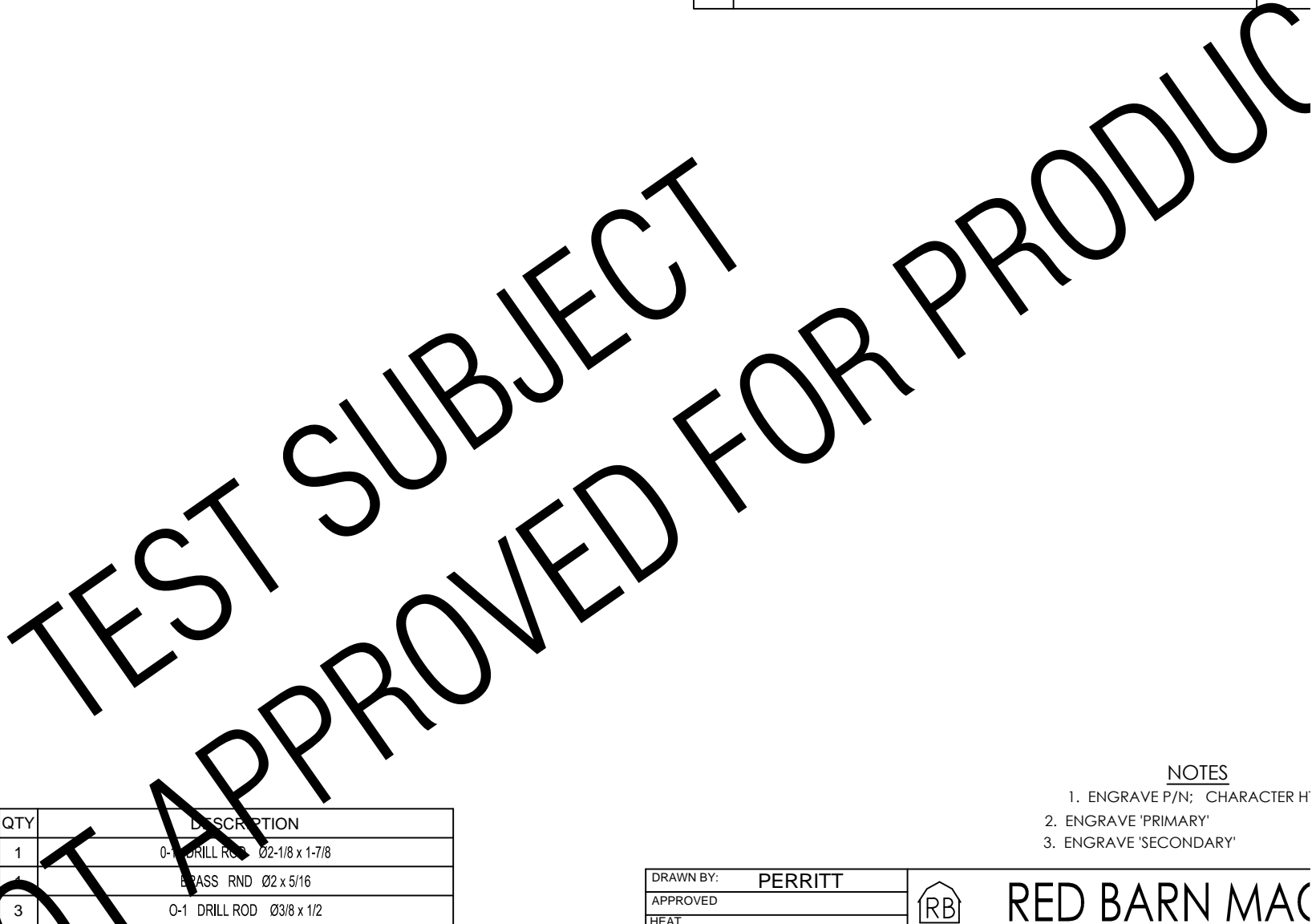
DRAWN BY: PERRITT

APPROVED

HEAT

RB

RED BARN MAC



TEST SUBJECT
NOT APPROVED FOR PRODUCTION

QTY	DESCRIPTION
1	0-1 DRILL ROD Ø2-1/8 x 1-7/8
	BRASS RND Ø2 x 5/16
3	0-1 DRILL ROD Ø3/8 x 1/2

NOTES

1. ENGRAVE P/N; CHARACTER H
2. ENGRAVE 'PRIMARY'
3. ENGRAVE 'SECONDARY'

DRAWN BY: PERRITT

APPROVED

HEAT

RB

RED BARN MACHINE CO.